

Highway Safety Corporation

Glastonbury, CT


Welding Procedure Specification

Material specification ASTM A36, A572 gr 50, A709 Gr 36, ASTM A709 Gr 50, A500 gr B, A53 gr B
 Welding process Gas Metal Arc Welding (GMAW) Spray Transfer
 Manual, semi-automatic, or automatic Semi-Automatic
 Position of welding Flat (1F) or Horizontal (2F)
 Filler metal specification AWS A5.18
 Filler metal classification ER70S-6
 Electrode and manufacturer Lincoln Electric Lincoln Weld L-56
 Flux and manufacturer N/A
 Shielding gas 86% Argon / 14% CO2 Flow rate 35-45 CFM
 Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current DCEP
 Polarity Reverse - electrode positive
 Welding progression Stringers
 Root treatment clean base metal
 Preheat and interpass temperature base metal up to 3/4" (50°F)
 Postheat treatment None
 Electrode extension 3/4" ± 1/4"

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
---	all	0.063"	300 A ± 30	29 V ± 2	15 lpm ± 2	<p>B-U2a-GF</p>
CK'D _____ NOV 14 2011 Resubmit BY _____		VTrans Received OK'd BY <i>JWC</i> APPROVED <i>[Signature]</i> DATE 11/15/11				

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in section 5 of latest edition AWS D1.5 / D1.1


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